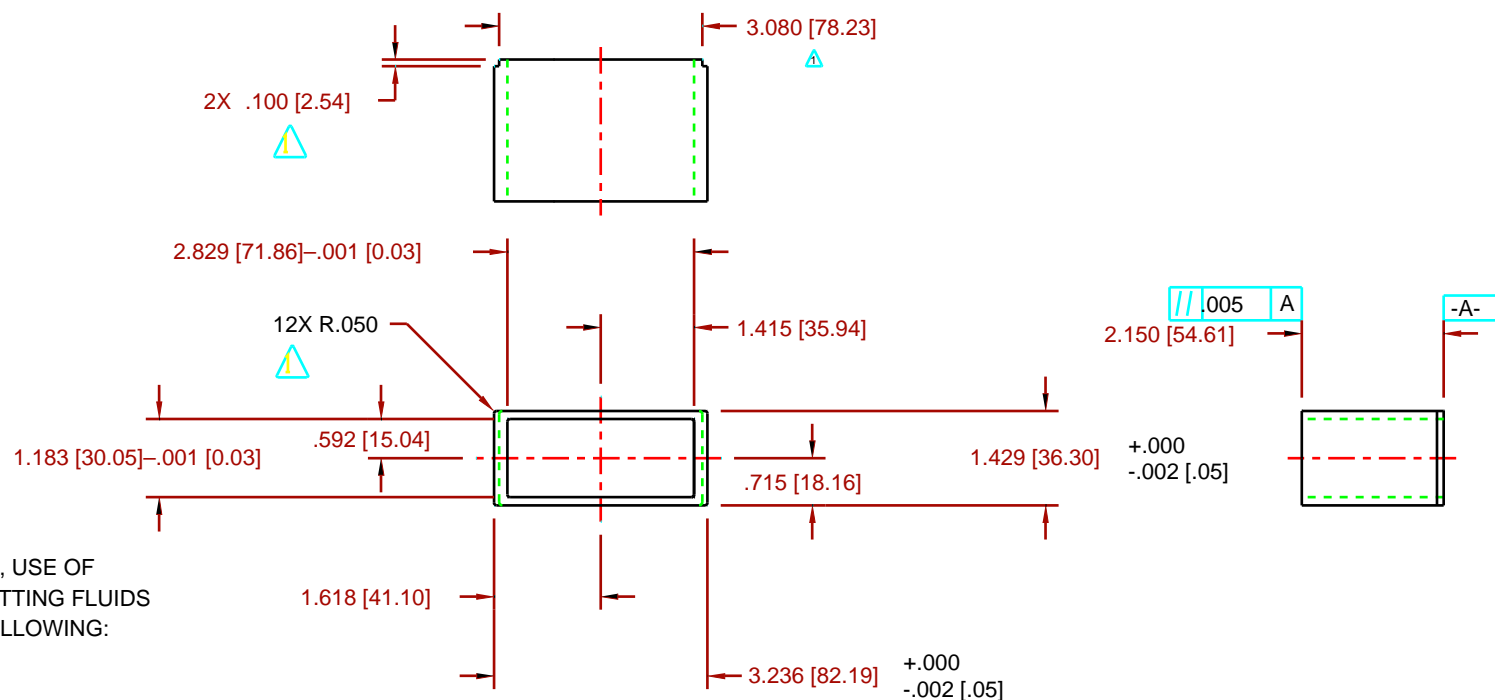


(B)

PLOT SCALE: .5=1

DWG. SCALE: 2

A1715001



## NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
1	12X R.050 WAS 8X R.050			
	3.080 [78.23] & .100 [2.54] ADDED	M.J.M.		
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, LOG NUMBER ALL DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS .X ± .03 [7620] .XX ± .01 [0.25] .XXX ± .005 [0.127] ANGULAR ± .25 ° SURFACE ROUGHNESS 125 ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
A1715001		ADVANCED PHOTON SOURCE M2 APS I.D. FRONT END 2-ND FIXED MASK RECTANGULAR EXTENSION TUBE		
DRAWN BY MUSCIA	DATE 3/17/94	CHIEF DESIGN ENGINEER D. SHU	DATE 3/25/94	
CHECKED BY J. WOTHE	DATE 3/22/95	GP LEADER T.M. KUZAY	DATE 3/25/94	
DESIGNER SHU/MUSCIA	DATE 3/25/94	PROJECT MGR.		
RESPONSIBLE ENGINEER D. SHU	DATE 3/25/94	APPROVED/RELEASED		
MATERIAL 304 STAINLESS STEEL		SCALE HALF	SIZE B	DRAWING NUMBER P4102010105-210006-01
DO NOT SCALE DRAWING		SHEET 1 of 1		